

Tuesday, 22/07/2008 11:27:06 AM
Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40709
Estimate Number : 13493
P.O. Number :
This Issue : 22/07/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : SMALL / MED FAB
Previous Rtn :
Written By :
Checked & Approved By : JLD 08-7-22
Comment : Est Rev:A 08-07-21 revB as per dwg DD verified by:EC

Drawing Name : FRONT RAIL, RH
Part Number : D37662
Drawing Number : D3766 REV B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 10/08/2008 **Qty:** 2 **Um:** Each

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6T1000W188

6061T6 RD TUBE 1.00 X .188W

Comment: Qty.: 2.9323 f(s)/Unit Total : 5.8647 f(s)

6061T6 RD TUBE 1.00 X .188W

batch:

M104488x1 / m104779x1

FF 08-07-23

(2)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to lenght as per dwg D3766

FF 08-07-23

(2)

2-drill holes thru to finish size as per dwg D3766

3- deburr

FF 08-08-11

(2)

PTC

3.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

S 08/08/11

J2 RH

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JL 08-08-11

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/08/11

(2) J2 RH

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3766-2 PAR #: NA Fault Category: Prod / Ins Ass. mod & small NCR: Yes No DQA: D Date: 08/08/11
 QA: N/C Closed: D Date: 08/08/12

NCR: <u>40709</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-08-11	2-2	16.10" hole was drilled 1.66" further than it was supposed to be. R/C: Employee did not measure as per dwg. Added on 1" somewhere	<u>Q51004</u>	Fill incorrect hole with weld, & sinking the hole 1st for proper weld penetration per Q51004 Rod M <u>1080976</u> Grinding flush	<u>BE</u> 08/08/11	<u>Q51004</u>	<u>Q51004</u>	<u>08-08-11</u>
			<u>Q51004</u>	drill hole as per dwg, And Ensure to double check all measurements before drilling	<u>FF</u> 08/08/11	<u>Q51004</u>	<u>Q51004</u>	<u>08-08-11</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT RAIL, RH

JobNumber: 40709

Part Number: D37662

JobNumber:



Seq. #

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



2x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 513

8/8/11

30

7.0

QC21

FINAL INSPECTION/W/O RELEASE



2

Comment: FINAL INSPECTION/W/O RELEASE

D 08/08/12

Job Completion



MF 08-08-11

Dart Aerospace Ltd

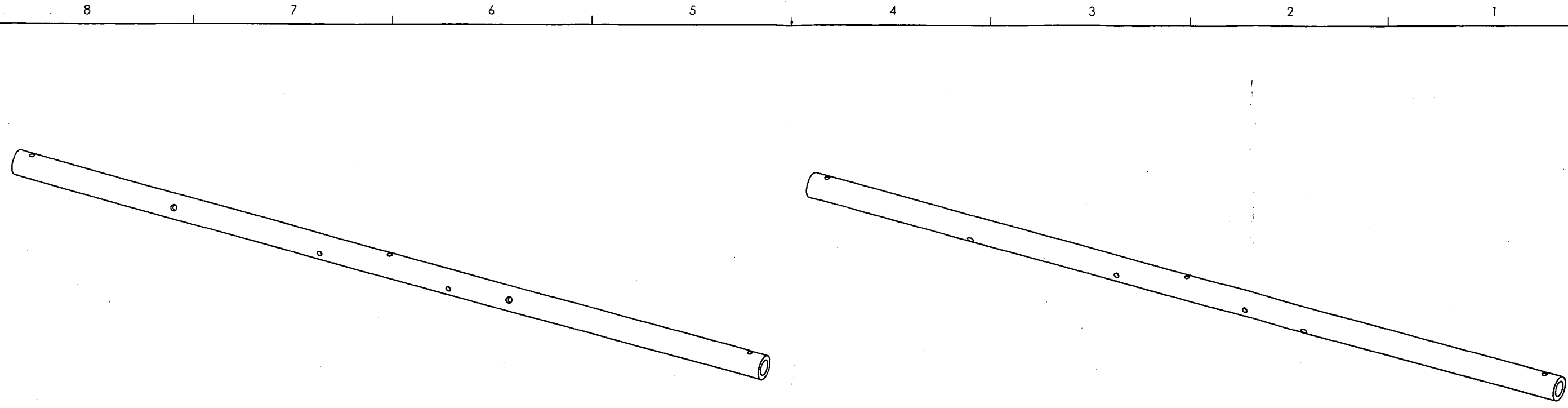
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3766-1 FRONT RAIL, LH

D3766-2 FRONT RAIL, RH

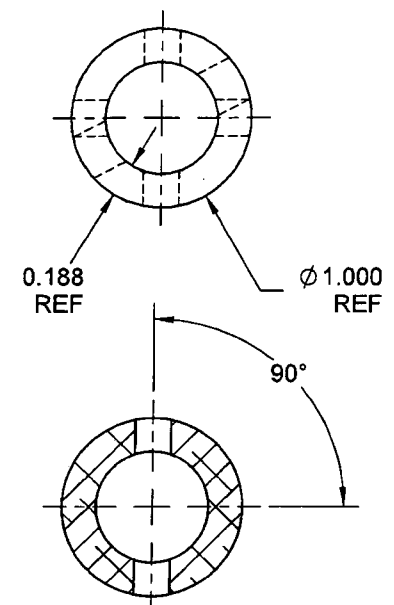
D3766-3 REAR RAIL

NOTES:
 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: D3766-1, 1.55 lbs
 D3766-2, 1.55 lbs
 D3766-3, 1.55 lbs

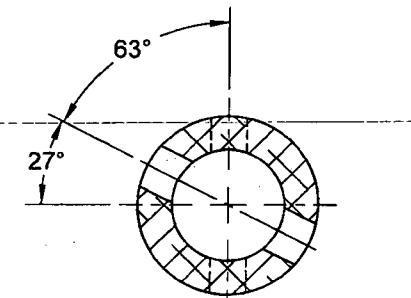
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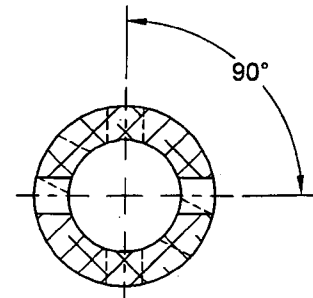
B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	MA	DRAWING NO.	REV. B
MFG. APPR.	MA	D3766	SHEET 1 OF 4
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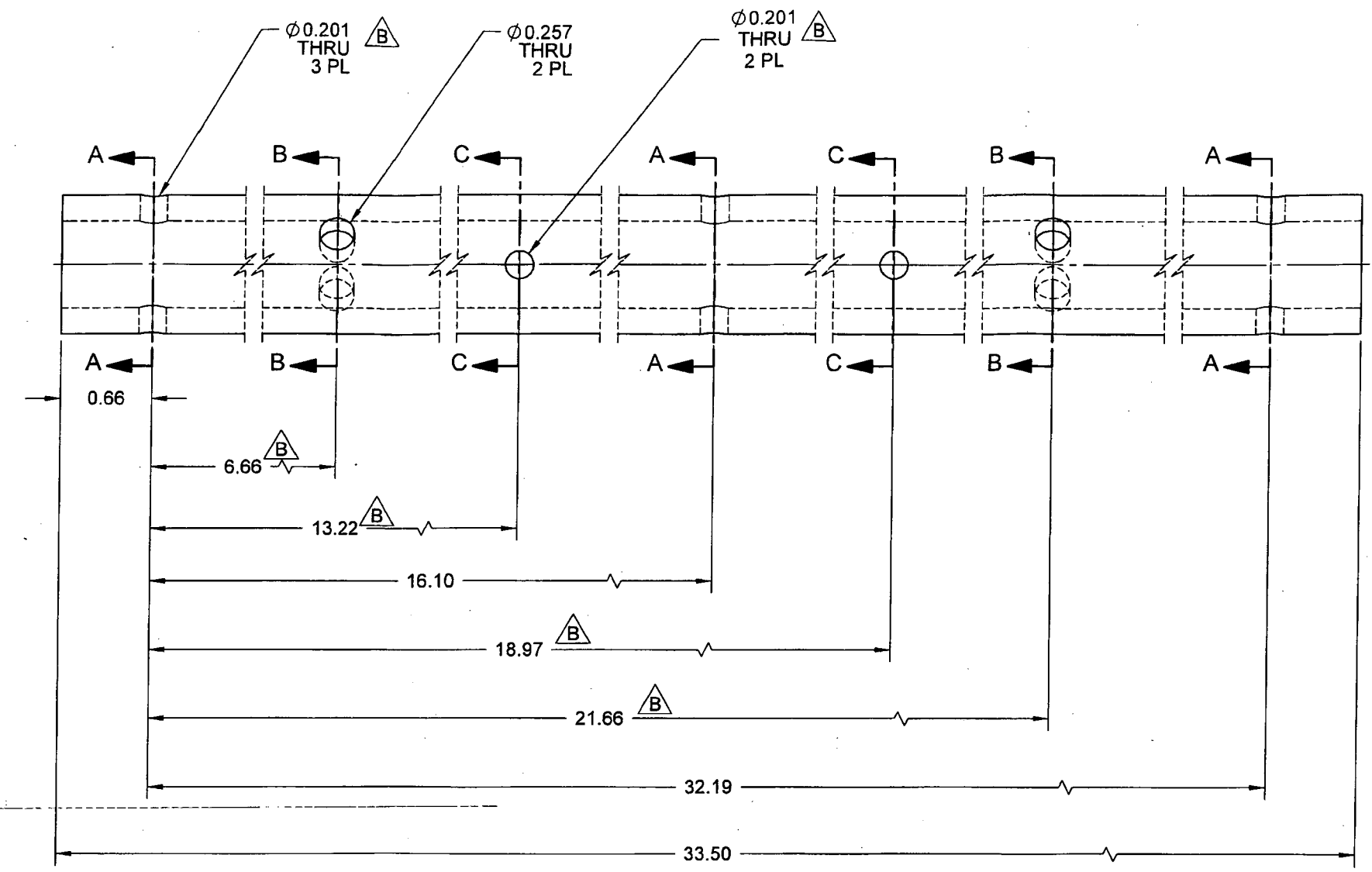
SECTION A-A



SECTION B-B



SECTION C-C

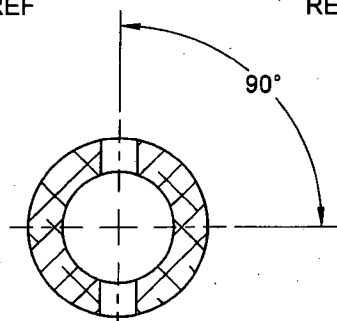
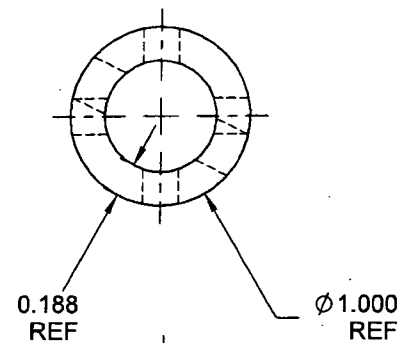


D3766-1 FRONT RAIL, LH

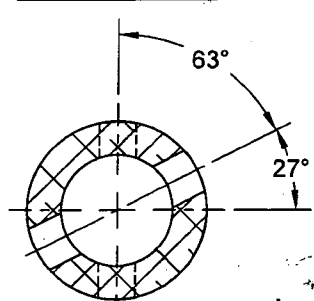
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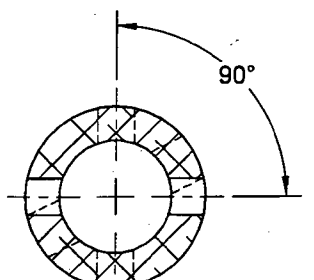
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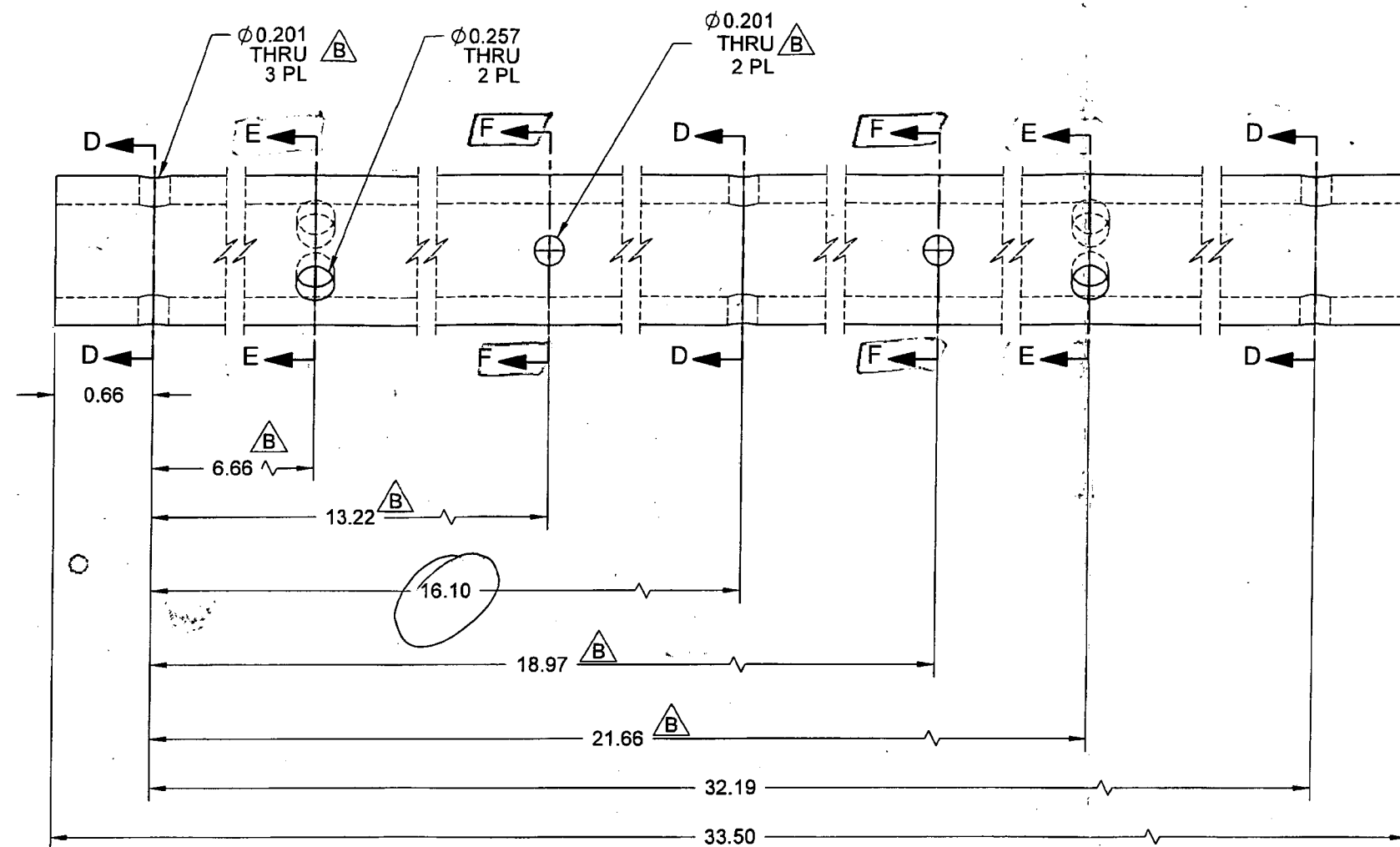
SECTION D-D



SECTION E-E







SECTION F-F



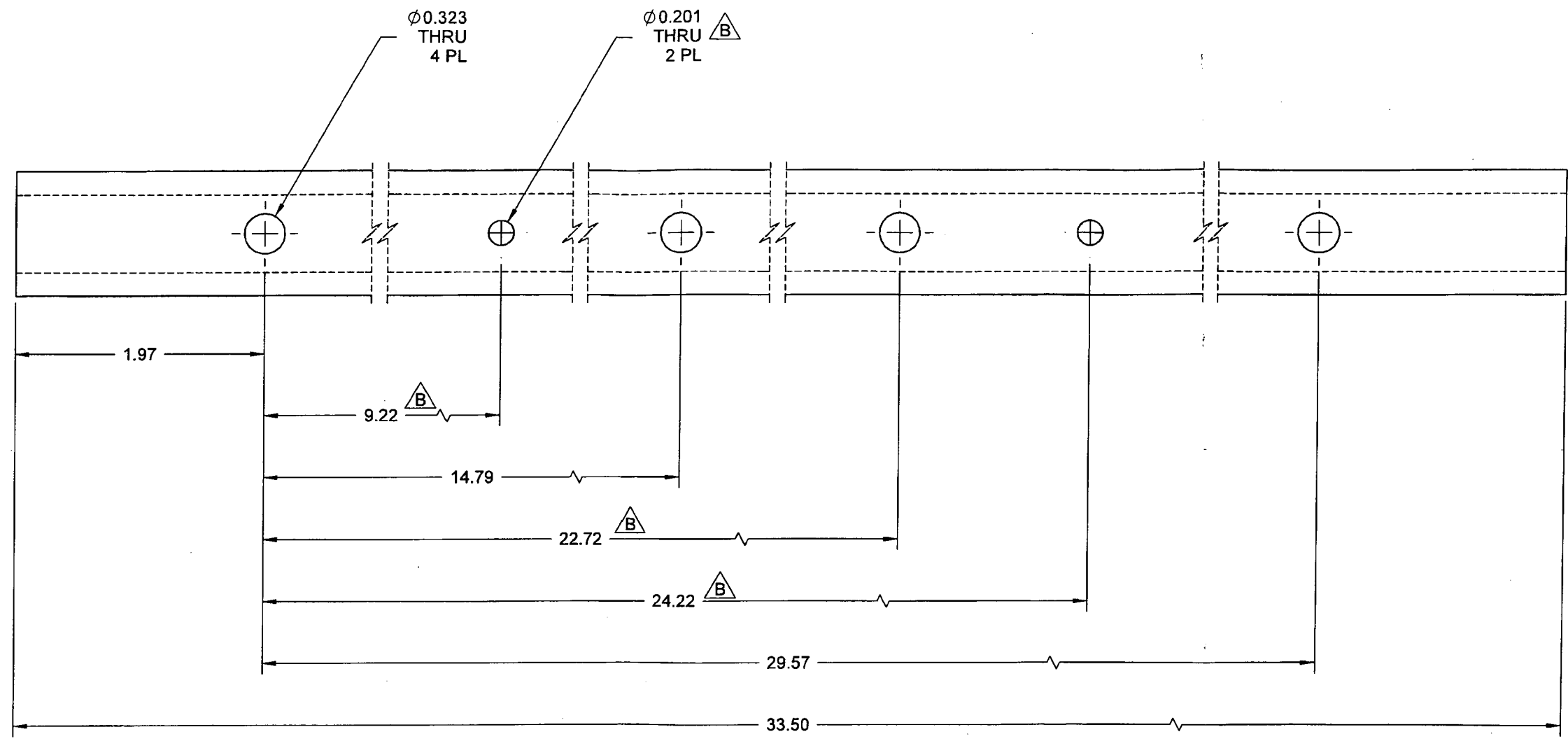
D3766-2 FRONT RAIL, RH

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0.188 REF
Ø1.000 REF



D3766-3 REAR RAIL

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WORK ORDER
NO. 60209

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